



**UNITED STATES ENVIRONMENTAL PROTECTION AGENCY  
REGION 5  
77 WEST JACKSON BOULEVARD  
CHICAGO, ILLINOIS 60604**

**DATE:** JUN 27 2017

**SUBJECT:** CLEAN AIR ACT INSPECTION REPORT  
Iroquois Bio-Energy Company, LLC

**FROM:** Gregory Gehrig, Environmental Engineer  
AECAB (MI/WI)

**THRU:** Sarah Marshall, Section Chief  
AECAB (MI/WI)

**TO:** File

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**BASIC INFORMATION**

**Facility Name:** Iroquois Bio-Energy Company, LLC

**Facility Location:** 751 West State Road 114

**Date of Inspection:** June 16, 2017

**Lead Inspector:** Gregory Gehrig, Environmental Engineer

**Other Attendees:** Charles Liapes, Environmental Health & Safety Manager, Iroquois Bio-Energy Company, LLC

**Purpose of Inspection:** CAA Compliance

**Facility Type:** Ethanol production from corn

**Regulations Central to Inspection:** SIP, NSPS and MACT

**Arrival Time:** 1255 hrs

**Departure Time:** 1455 hrs

**Inspection Type:**

- ☒ Unannounced Inspection  
☐ Announced Inspection

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### **OPENING CONFERENCE**

- ☒ Credentials Presented
- ☒ CBI warning to facility provided

The following information was obtained verbally from Mr. Liapes.

**Company Ownership:** Same ownership since at least 2011.

### **Process Description:**

Iroquois Bio-Energy, LLC (Iroquois) is permitted to produce 60 million gallons per year of ethanol from corn. They also produce distillers dried grains (DDGS). The facility was designed by ICM and constructed by Fagen. They have four fermentors, one beer well and one associated scrubber for pollution control. They have a pre-condenser on their scrubber. Iroquois uses one RTO to control emissions from the mash drying operations conducted to DDGS. They load out denatured ethanol via both rail and tank wagon.

### **TOUR INFORMATION**

**EPA toured the facility:** Yes

### **Data Collected and Observations:**

Iroquois was operating normally during the facility tour. The following was observed during the tour:

- Control room.
- Grain offloading, hammermilling and transfer to cook tank.
- Scrubber, which was operating at a pressure differential of 14.6 inches of water and a flow of 84.5 gallon per minute of water.
- Fermentors and beer well. Fermentor #4 was being filled at the time of the inspection.
- Distillation.
- Rail and truck loadout, including vapor combustors (flares).
- Product storage tanks and denaturant storage tank.
- RTO, which was operating at 1,511.9 °F on a 3-hour rolling average.

FLIR video was taken of VOC emission points and possible VOC emission points. In particular, VOCs were observed venting uncontrolled from pressure release valves (PRVs), fittings and agitators at the top of the fermenters and beer well.

**Field Measurements:** were not taken during this inspection.

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**RECORDS REVIEW**

- Limited review of Renewable Fuels Standards (RFS) applicable to facility on a worksheet, treated as CBI.

**CLOSING CONFERENCE**

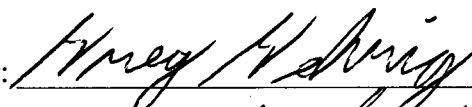
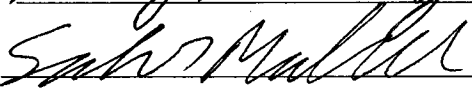
**Requested documents:**

- Various for RFS, to be send via email after inspection.

**Compliance Assistance:** Iroquois should mitigate uncontrolled venting from PRVs, fittings and agitators at the top of the fermenters and beer well.

**Concerns:** None

**SIGNATURES**

Lead Inspector:  Date: 6-19-17  
Section Chief:  Date: 6/21/17

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**APPENDICES AND ATTACHMENTS**

- Seven FLIR videos